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RBE350A94-3700-B
Job Sheet 192645



Part No: RBE350A94-3700-B

Job Qty: 1 pcs

Part Name: Swashplate Immobilizing Tool, Short Brace Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/28/19

Job Tracking No:

Due Date: 4/1/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBE350A94-3700-B Rev. 6 IPP Rev. A 18.08.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	4/1/19		0.00	0.10	Small Fab - 1		<i>Mee</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	4/1/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	1 pcs	4/1/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S168471



Part: RBE350A94 - 3700 - B

Job No: 192645

Serial No/Batch: S168471

Revision: 6

Inspector:

Exp Date:

Instructions:

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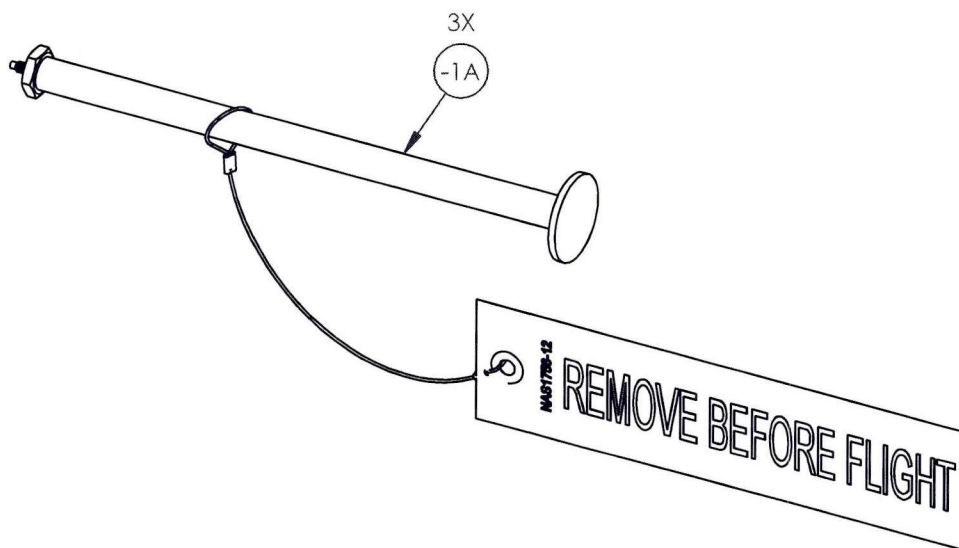
Date: 04/01/19

DAS
40
9-89
APR 02 2019

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLC
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	4/1/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53
Part Op 110 - (Small Fab) 1-Pick bag and tag. Descriptions: 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
RBE350A94-3700-B-1A	Short Brace Assembly	3 pcs (3 ea)	110-Small Fab - 1	5167682	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Small Fab - 1	RBE350A94-3700-B-1A	3	0	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		BROKE OUT FROM KIT AS INDIVIDUAL TOOL.	8/21/2012	RJC	RW
5		CH'D T/N WAS RBEA94-3700-B IS RBE350A94-3700-B. -01 CH'D DIM WAS $\varnothing.75$ IS ($\varnothing.75$), WAS .083 IS (.083). -03 CH'D DIM WAS $\varnothing.570$ ∇ .079 IS $\varnothing.570$, ADDED DIM $\varnothing.586$ P.F. -01, ($\varnothing.20$). -05 CH'D DIM WAS $\varnothing 2.00$ IS ($\varnothing 2.00$), WAS $\varnothing.586$ P.F. -05 IS $\varnothing.586$ P.F. -01. CH'D TOLERANCE ON NON-CRITICAL PARTS.	5/23/2014	DPD	RJC
6	16-0151	UPDATED TO NEW DRAFTING STANDARD. DELETED P/N B , ADDED P/N'S -1A , -09 , -011 , -013 . CH'D -07 DESCRIPTION WAS SOCKET HEAD SET SCREW DOG POINT IS SOCKET HEAD SET SCREW EXTENDED POINT. -1A ADDED DRAWING. -01 , -03 , -05 ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D. -01 CH'D DIM WAS ($\varnothing.75$) IS $\varnothing.75$, WAS (.083) IS .08. ADDED DIMS $\varnothing.6047/.6040$ (P.F. -03), $\varnothing.6047/.6040$ (P.F. -05), .88, .88, 2X .03 X 45°, ADDED ENGRAVE NOTE. -03 CH'D DIM WAS $\varnothing.586$ P.F. -01 IS $\varnothing.6056/.6052$ (P.F. -01). -05 CH'D DIM WAS $\varnothing.586$ P.F. -01 IS $\varnothing.6056/.6052$ (P.F. -01), WAS ($\varnothing 2.00$) IS 2.00, CH'D MATERIAL WAS 1018 IS 1018/1020 CR.	2/24/2017	RJC	SM



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1A	3	SHORT BRACE ASSEMBLY			2
	1		-01		TUBE	STEEL		3
	1		-03		CAP	SP HEX		4
	1		-05		FOOT	1018/1020 CR		5
	1	B/O	-07		SOCKET HEAD SET SCREW, EXTENDED POINT	STEEL	M6 X 1 X 30mm (MCMaster-CARR #92905A225)	2
	1	B/O	-09		REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
	1	B/O	-011		LANYARD CABLE	COATED STEEL	$\varnothing 1/16$ X 8 (CARR LANE #CL-2-C)	2
	2	B/O	-013		FERRULE	ALUMINUM	$\varnothing 1/16$ X 3/8 (MCMaster-CARR #3896T31)	2
	ASSY -1A							

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL SHORT BRACE ASSEMBLY	
DWG NO. RBE350A94-3700-B	REV 6
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
FINISH	.XX $\pm$.01 ANGLES $\pm$ 5°
SPEC	.X $\pm$.1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EUROCOPTER AS350/355
SCALE 1:4	DATE 8/21/2012 SHEET 1 OF 5